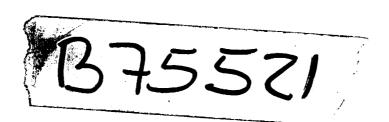
Work Orde October-24-11		521		*755	521*							Page 1
Revision ID:	D350-636-01 Skidtube LH	3		Accept	*N900	)040	100	)*	Setup (	Start Stop	*N:	S1* S2*
	24/10/2011 07/11/2011	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item Customer:						1 W	
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Sequence ID/ Work Center II	)	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Rejec Qty		Reject Number	Insp. Stamp
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#### Work Order ID 75521

October-24-11 1:00:39 PM

Skidtubes



Page 2

D350-636-013 Item ID: \*N900040100\* Setup Start Revision ID: Item Name: Skidtube LH **Start Date:** 24/10/2011 Start Qty: 1.00 **Cust Item ID: Required Date: 07/11/2011** Req'd Qty: 1.00 **Customer:** Reference: Run Approvals: Process Plan: Date: Tooling: Date: Stop Date: SPC (Y/N): Date: **Tool ID** Tool # Plan Sequence ID/ Operation Set Up/ Accept Reject Reject Insp. **Qty Work Center ID** Description **Run Hours** Code Qty Number Stamp 110 0.00 Skidtubes \*110\* Skidtubes 0.00 Memo

1- Pick D2600-3 Bent

2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside AFT end per dwg D2750

- 3- Drill pilot holes for blade fitting bolt holes using DT8983. Open to 0.500", deburr.
- 4- Locate DT8330 off of blade fitting bolt holes and drill pilot holes for blade fitting
- 5- Drill only two fwd step holes using DT9616. Ensure proper positioning.



6- Drill pilot holes as per Dwg D2750 sheet 4 (D2750-3 details). Drill using drill Jig DT8150 & DT8861A for first side only DT8861B for second side (detail B)



7- Clecko DT886 B on second side of tube and drill pilot holes for detail B. \*\*\*SECOND SIDE\*\*\*

8- Open up holes for SECTION AW-AW to 0.375" (2 holes per side) and blade fitting location holes to 0.500" (total of 4 holes per side) as per dwg D2750. Open holes for ground handling and detail T to 0.500" (8 holes per side)

9-Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to 0.297".

10-Open up holes of Detail A to 0.297" (total of 2 holes per side)

W/O:			WORK ORDER CHANGES								
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Page 3

October-24-11	1:00:39 PM								
Item ID: Revision ID:	D350-636-01	3		Accept	*N900	040100	* Setup	Start	*NS1*
Item Name:	Skidtube LH							Stop	*NS2*
Start Date:	24/10/2011	Start Qty: 1.00	*1*		Cust Item II	D:			
Required Date:	07/11/2011	<b>Req'd Qty:</b> 1.00	*1*		Customer:				
Reference:								-	
Approvals:	Process Pla	n:	Date:	Tooling:	Da	te:	Run	Start	*NR1*
	QC:		Date:	_ SPC (Y/N):	Da	te:		Stop	*NR2*
Sequence ID/ Work Center II	)	Operation Description		Set Up/ Run Hours	Tool ID		Accept Re Qty Qt		Reject Insp. Jumber Stamp
.*		from bendin A/R Alum	2744 Cap as per Dwg D27 g as per QSI 004 inum Rod batch:		es in bend left  BE B/04/10	- John Me	12-4	1-10	s.
120		QC10- Inspect visual per	QSI004- ground welds	0.00	. /	/			
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Work Order ID 75521 \*75521\* October-24-11 1:00:39 PM Item ID: D350-636-013 Accept \*N900040100\* Setup Start **Revision ID:** Skidtube LH Item Name: Start Qty: 1.00 24/10/2011 **Start Date: Cust Item ID: Required Date:** 07/11/2011 **Req'd Qty:** 1.00 **Customer:** Reference: Run Process Plan: Tooling: Date: Approvals: Date: Stop Date: SPC (Y/N): Date: Sequence ID/ **Operation** Set Up/ Tool ID Tool # Plan Reject Reject Accept Insp. Work Center ID Description **Qty** Qty Stamp Code **Run Hours** Number 140 Chemical Conversion Coat per OSI005 4.1 0.00 \*140\* HandFinish 0.00 Memo

150

QC3- Inspect Part Finish

0.00

\*150\*

Hand Finishing

QC Quality Control

Memo

0.00

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Page 4

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Work Order ID 75521 \*75521\* Page 5 October-24-11 1:00:39 PM D350-636-013 Accept \*N900040100\* Item ID: Setup Start **Revision ID:** Item Name: Skidtube LH 24/10/2011 Start Qty: 1.00 **Start Date: Cust Item ID: Req'd Qty:** 1.00 **Required Date: 07/11/2011 Customer:** Reference: Run Start Process-Plan: Date: **Tooling:** Date: **Approvals:** Stop OC: Date: SPC (Y/N): Date: **Tool ID** Reject Insp. Tool # Plan Accept Reject Sequence ID/ Operation Set Up/ Code **Qty** Oty Number Stamp **Work Center ID Description Run Hours** 0.00 160 Skidtubes \*160\* 0.00 Skidtubes Memo 1-Open up holes section AW-AW 0.500" (4 per side) as per dwg D2750 Skidtubes 3-Open up holes of Detail T and ground handling to 0.625" (total of 8 holes per side Detail AV-AV) as per dwg D2750. 4-Chamfer holes of section AW-AW, AV-AV, T and ground handling. (welding instructions on sheet 10) 5-Deburr and blow out all chips from inside of tube. Prepare tube for welding, remove alodine as required. 6-Bond web D2739 in place as per QSI Q15 batch: 12/08 A/R Sikaflex-291 exp. date: 12/08/13 7- Weld spacers D3490-1, D3490-5 and D2743 as per dwg D2750 & QSI004 (welding instructions on sheet 10) A/R Aluminum Rod batch: M/A 8-Grind welds flush as per Dwg D2750 \ 9-Spot face ground handling holes (total of 4 places per side) as per dwg D2750 10-Deburr holes

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	Work Order ID 75521 October-24-11 1:00:39 PM		*75521*								Page 6
Item ID: Revision ID: Item Name:	D350-636-01 Skidtube LH	13		Accept	*N900	<u>040</u>	100	<b>)</b> *	Setup Sta		S1* S2*
Start Date: Required Date: Reference:	24/10/2011 : 07/11/2011	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item I Customer:	D:					. 1/
Approvals:	Process Pla	n:	Date:	Tooling:SPC (Y/N):		ate:		F	Run Sta Sto	I <i>Z</i> I	R1* R2*
Sequence ID/ Work Center II  170 *170* QC Quality Control	D	Operation Description QC10- Inspect visual per	QSI004- ground welds	Set Up/ Run Hours 0.00	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
*180 *180* QC Quality Control		QC5- Inspect part comple	eteness to step on W/O	0.00	(ay)>						

190

\*100\*
HandFinish

Hand Finishing

Pressure Wash per QSI005 4.3

Memo

Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.

0.00

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HandFinishing

1-Install inserts as per dwg D2750

HandFinish

Hand Finishing

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October-24-11 1:00:39 PM D350-636-013 Accept \*N900040100\* Item ID: Setup Start **Revision ID:** Item Name: Skidtube LH **Start Date:** 24/10/2011 Start Oty: 1.00 **Cust Item ID:** Req'd Qty: 1.00 **Required Date: 07/11/2011 Customer:** Reference: Run Approvals: Process Plan: Date: **Tooling:** Date: Stop SPC (Y/N): Date: Date: Sequence ID/ **Operation** Set Up/ Tool ID Tool # Plan Accept Reject Reject Insp. Work Center ID Description **Run Hours** Code Oty Otv Number Stamp 230 0.00 Mulo4/10 HandFinishing \*230\* HandFinish 0.00 Memo Hand Finishing 1-Inspect for Foreign Objects \_\_ 2-Spray inside of tube with "LPS-3" batch:\_\(\mathcal{U}\) \( \mathcal{U} \) 3-Install blade fitting D3488-041, wearshoes and ground handling hardware as per dwg D2750 SIKA FLEX 241 BATCH: 1/ 12 (22) EXP DATE: (3 ) 6 4-assemble o'ring to plug as per dwg D3492 and apply o'ring lube A/R 55-o'ring lube batch: AL (03-)2 5-Coat all exposed fasteners with "LPS Procyon" batch: 1596 240 QC5- Inspect part completeness to step on W/O

Memo

5/2/4/19

Quality Control

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<b>Work Order ID 75521</b> October-24-11 1:00:39 PM			*75521*						Page 9		
Item ID: Revision ID:	D350-636-0	13		Accept	*N900	004010	<b>N</b> *	Setup	Start	*N	S1*
Item Name:	Skidtube LH								Stop	*N	S2*
Start Date:	24/10/2011	Start Qty: 1.00	*1*		Cust Item	ID:					
Required Date:	: 07/11/2011	<b>Req'd Qty:</b> 1.00	*1*		Customer:						
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Sequence ID/ Work Center II	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool # Plan Code		t Reje Qty		Reject Number	Insp. Stamp
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Packaging		Memo		0.00							
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260		QC4- 100% Inspect kits	for completeness	0.00							
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*270*		Packaging		1/40-1	<b>v</b>		1			12-14	100
Packaging		Memo		0.00 72							1

Memo

Package as per PPP D350-636-013

Packaging

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Item ID: D350-636-013 Revision ID: Item Name: Skidtube LH				Accept	*N900	<b>04</b> 0	100	)*	Setup Star	1/1	S1* S2*
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Approvals: Process Plan:QC:		Date:	Tooling: SPC (Y/N):		nte:		J	Run Star Stoj	, "I <b>V</b> I	R1* R2*	
Sequence ID/ Operation Work Center ID Description			Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp	

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QC21- Final Inspection - Work Order Release

Memo

280

\*280\*

Quality Control

M3-04-23

Page 10

W/O:			WC	RK ORDER CHANGES								
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Part No					NCR: Yes No DQA: Date: _							
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October-24-11 1:00	)-43 PM											Page
Work Order ID: 755	<del></del>		<u>*</u>	75504	*							
	350-636-013			75521		40+						
Parent Item Name:	Skidtube LH		^	)350-	-636-0°	13°			Start Date: 24 Start Qty: 1.0		_	l Date: 07/11/2011 d Qty: 1.00
Comments:	IPP Rev:H02.09.25 IPP rev I 06.03 IPP Rev:J 07-07- IPP Rev:K 08-09- 10.06.22 revise seq per IIN revH DD v	Added SS W -23 revF as per d 1110 DD verf:EC	dwg /earplat lwg D	E tes(Rev E) JL D verified by	CC M Verified B y:ec IPP Ro P Rev:M 10.10	ev:L						
Component Item ID/ tem Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	t Total Qty	Qty Issued	Date Status Issued
22600-3-BENT *D2600-3 Extrusion Bent	-RFNT*	Manufactured	No			110	Each	40.0000	**		Bizlo	4/05
				<u>Location</u> LG	8234	7 Loc	<u>Oty</u> 40	Loc Code	_			L
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03493-1					75023				-		-	
	<b>4</b>	Manufactured	No		75023	110	10 Each	51.0000	2	2 ~		
°D3493-1	*	Manufactured	No		75023		10 Each			2 V 78835	<i>33</i>	12/04/
°D3493-1	*	Manufactured	No	Location ST062		110 <u>Loc</u>	10 Each • • • • • • • • •	51.0000 <u>Loc Code</u>			33	12/64/
*D3493-1 Vasher	*	Manufactured  Manufactured	No No	ST062			10 Each • •				<i>33</i>	12/64/
*D3493-1 Vasher  2739 *D2739*	*			ST062	70697 71846	<b>Loc</b> 160	10 Each  • Oty 51 13 38	Loc Code			<i>\$ 3</i>	12/04/
*D3493-1 Vasher	*			ST062	70697 71846	<b>Loc</b> 160	10 Each  . Oty 51 13 38 Each	Loc Code	** -		33	

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October-24-11 1:00:43 PM

\*75521\* 'Work Order ID: 75521 D350-636-013 \*D350-636-013\* Parent Item: Parent Item Name: Skidtube LH **Required Date:** 07/11/2011 **Start Date: 24/10/2011** Start Qty: 1.00 Required Qty: 1.00 D2744 Manufactured No 160 Each 59.0000 \*D2744\* \*\* Location Loc Qty Loc Code LG002 13 62715 70881 12 WA 46 71861 46 D3490-1 Manufactured No 160 Each 26.0000 \*\* Cross Bolt Spacer Location Loc Qty Loc Code LG 24 5 67773 71841 19 LG001 2 62450 D3490-5 Manufactured No 160 Each 36.0000 \*\* Cross Bolt Spacer Loc Qty Location Loc Code LG001 36 59230 36

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		·	Chief Eng	Chief Eng		Date				

#### **Picklist Print** Page 3 October-24-11 1:00:43 PM · Work Order ID: 75521 \*75521\* Parent Item: D350-636-013 \*D350-636-013\* Parent Item Name: Skidtube LH Start Date: 24/10/2011 Required Date: 07/11/2011 Start Qty: 1.00 Required Qty: 1.00 D2743 Manufactured No 220 Each 167.0000 \*D2743\* \*\* Crossbolt Spacer Location Loc Oty Loc Code LG 109 71839 45 73403 64 LG001 58 67766 4 68251 54 ALS4-1032-225 Purchased No 230 2,601.000 Each 38 \*ALS4-1032-225\* M1121269 (x38) Il 1104/16 \*\* Insert Location Loc Qty Loc Code ST281 2601 108696 749 110768 62 118386 860 118966 930 AN3C5A 230 Purchased No 1,316.000 Each 34 34 \*AN3C5A\* \*\* 11120423 (x34) Mylcall Location Loc Oty Loc Code FP-A 7 115835 ST350 1309 116419 28 117343 110

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	Res	solution:	Disposition: QA: N/C Closed: Date						
NCR:			WORK ORDE	R NON-CONFORMAN	ICE (NCF	R)			
		Description of NC		Corrective Action Section		Verificatio	n Approval	Approva	
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspecto	
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Picklist Print October-24-11 1:00:43 PM									Page 4
Work Order ID: 75521		*7	5521*						
Parent Item: D350-636-013 Parent Item Name: Skidtube LH			)350-636-0	713*	13*		art Date:	24/10/2011 1.00	Required Date: 07/11/2011 Required Qty: 1.00
AN3C6A	Purchased	No		230	Each	224.0000	4	4	
*AN3C6A*							**	11106	93 (x1) M 12/04/1
			<b>Location</b>	<u>Lo</u>	c Oty	Loc Code			
			FP-A		1				
			111982		1				_
			ST351		223				_
			111982		2				_
			116419		23				_
			116549		2				-
			116704		12	*			-
			117619 117688		10				-
			117872		1 5				-
			118422		168			-	-
AN6C44A	Purchased	No		230	Each	105.0000	4	4	-
*AN6C44A*							**	111150	165 (xx) H101110
			<b>Location</b>	Loc	: Oty	Loc Code			
			FG		2				
			103964		2				
			ST343		103				
			118387		33				
			118985		40				
			119125		30				

W/O:			WORK ORDER CHANGES								
DATE	STEP	PRO	OCEDURE CHAN	IGE	В	у	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
						-					
		·									
							· · · · · · · · · · · · · · · · · · ·				
Part No	):	PAR #:	Fault Categ	jory:	NCR: Yes No DQA: Date						
	Res	olution:	Disposition	ı:	QA: N/	C Clo	osed: Date:				
NCR:			WORK ORDE	ORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC			tion B			cation	Approval	Approval	
DATE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng		gn & Date	Secti	on C	Chief Eng	QC Inspector	
,											
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1	1							I	1		

Picklist Print October-24-11 1:00:44 PM									Page 5
Work Order ID: 75521	· · · · · · · · · · · · · · · · · · ·	*75	5521*						146.
Parent Item: D350-636-013 Parent Item Name: Skidtube LH			350-636-	<b>013</b> *			rt Date: art Qty:	24/10/2011 1.00	Required Date: 07/11/2011 Required Qty: 1.00
*AN8C35A *AN8C35A* BOLT	Purchased	No		230	Each	111.0000	1 **	1 	12/04/18
			<u>Location</u>	<u>La</u>	oc Qty	Loc Code			
			FP		75				-
			117511		9				
			118286		66				-
			FP-A 115960		1				
			ST345		34				
			117834		34			X	
			ST346		1				
			114442		0				
			115188		0				
AN960C10L NAS1149C0332	Purchased	No	115960	230	l Each	0.0000	38	38	
*AN960C10I **							**	*111212	55 (x38) & luloul
D2745	Manufactured	No		230	Each	149.0000	8	8	
*D2745* 💥							**	138196	4 (xg Mulo4/1

W/O:		4.0	WO	RK ORDER CHANG	GES				
DATE	STEP	PRO	OCEDURE CHAN	IGE	Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
Port No		PAR #:	Fault Cateo	lory:	NCR: Yes	No DOA:	Date:		
		esolution:							
NCR:				R NON-CONFORM					
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Sec Action Description Chief Eng	tion B Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Office Ling	Children's					
							, "		

Picklist Print October-24-11 1:00:44 PM									Page 6
Work Order ID: 75521		*755	521*		11.				
Parent Item: D350-636-013			50-636-	<b>012</b> *					
Parent Item Name: Skidtube LH		1 7.3	. )( )-( ). )( )-	(71.)			tart Date: Start Qty:	: 24/10/2011 : 1.00	Required Date: 07/11/2011 Required Qty: 1.00
D3488-041	Manufactured	No		230	Each	17.0000	1	1	
*D3488-041* Blade Fitting Assembly, LH							**	BAAO	er (x1) M world
		<u>I</u>	ocation	Lo	oc Qty	Loc Code			
		F	P		7				-
			69903		7				_
		F	P007		1				
			61689		1				_
		F	P008		9				_
			67788		1				_
			71887		8				-
D3492-1	Manufactured	No		230	Each	142.0000	8	8	
*D3492-1*							**	38196	3 (x8) Jul Mouli
		L	<u>ocation</u>	<u>Lo</u>	c Qty	Loc Code			
		F	Р		142				_
			69531		8				_
			73402		54				

\*D3492-5\*

D3492-5

Manufactured

Location Loc Oty FP 32

230

80

32

Each

70698

74444

Loc Code

32.0000

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377044 (xx) Ill 1216461

Dart Ae	rospace	e Ltd								•		
W/O:			V	VORK ORDER CHANGI	ES				ų			
DATE	STEP	PROC	CEDURE CHANGE			Зу	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
Part No: PAR #:		PAR #:	Fault Category: N			CR: Yes No DQA: Date:						
Resolution:			Disposition: QA: N/C Closed: Date:									
NCR:		W	ORK OR	DER NON-CONFORMA	NCE (	NCR)						
DATE	STEP	Description of NC	Corrective Action Section B				Verific	ation	Approval	Approval		
DATE	SILF	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Section C		Chief Eng	QC Inspector		
								,				
	ļ						-			· · · · · · · · · · · · · · · · · · ·		

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Work Order ID: 75521		*7	5521*						
Parent Item: D350-636-013			350-636-0	13*					
Parent Item Name: Skidtube LH							tart Date: Start Qty:	: 24/10/2011 : 1.00	Required Date: 07/11/2011 Required Qty: 1.00
D3535-25	Manufactured	No		230	Each	15.0000	1	1	
*D3535-25*							**	08033	s (xi) Il noule
			<b>Location</b>	Loc	e Qty	Loc Code			
			FP018		15				
			62233		1				
			73424		2				
			74592		12				
D3536-25	Manufactured	No		230	Each	45.0000	1	1	
*D3536-25*							**	137890	2 (x1) Il 12/04/10
			<b>Location</b>	Loc	: Oty	Loc Code			
			FP012		45				
			74526		7				
			74595		12				
			75039		26				
D3537-1	Manufactured	No		230	Each	55.0000	3	3	
*D3537-1*							**	373716	(x3) Il interfed
			Location	Loc	Oty	Loc Code			
			FP002		48				
			74597		48				
			FP017		7				
			69817		5				
			70686		2				
03631-1	Manufactured	No		230	Each	91.0000	8	8	
*D3631-1*							**	13755	18 (x8) Al nloule
			Location	Loc	Oty	Loc Code			
			ST072		91				
			68062		91				

							•		
W/O:			WC	ORK ORDER CHANG	ES				•
DATE	STEP	PR	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
٠									
Part No	:	PAR #:	Fault Cate	gory:	NCR: Yes	No DQ	1 <b>1</b> :	Date: _	<u> </u>
Resolution:		Disposition	QA: N/C Closed: Date:						
NCR:			WORK ORDE	ER NON-CONFORMA	NCE (NCF	<b>?</b> )		· · · · · · · · · · · · · · · · · · ·	
		Description of NC		Corrective Action Section		Verific	fication Appro		Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	k Section		Chief Eng	QC Inspector
								:	
							i		*
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October-24-11 1:00:44 PM										Page 8	
Work Order ID: 75521		*7	5521	*							
Parent Item: -D350-636-013			*D350-636-013*								
Parent Item Name: Skidtube LH		1 7. ). )( )-( ), )( )-(			,,,,		s	tart Date	: 24/10/2011	<b>Required Date:</b> 07/11/2011	
							;	Start Qty	: 1.00	Required Qty: 1.00	
D3791-1	Manufactured	No			230	Each	26.0000	1	1		
*D3791-1* Wearplate								**	137889	7(x) 11 n104/15	
			Location	1.	. <u>L</u> e	oc Qty	Loc Code				
			FP017			26				-	
				62239		2				-	
				74527		12				-	
D2502 1				74598	220	12	10.000			-	
D3793-1	Manufactured	No			230	Each	19.0000	I	l		
*D3793-1* Wearshoe					•			**	37890	or (x1) Il noul (d	
			Location	1	Lo	oc Oty	Loc Code				
			FP001			6					
				73422		6					
			FP018			13					
	,			74591		13					
D3793-3	Manufactured	No			230	Each	11.0000	1	1		
*D3793-3* Wearshoe								**	B 789	35 (x1) M 12/04/1	
			Location		Lo	e Qty	Loc Code				
			FP001			11			****		
				74593		11					
D3794-1	Manufactured	No			230	Each	52.0000	1	1		
*D3794-1*								**	380439	5 (x1) M (2/04/17	
			<b>Location</b>		<u>Lo</u>	c Qty	Loc Code				
			FP014			52				·	
				74529		12					
				74594		12					
				75042		28					

Dart Ae	rospace	e Ltd									
W/O:			W	ORK ORDER CH	ANGES				•		
DATE	STEP	PRO	CEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
,					20-120-1						
Part No: PAR #:			Fault Category: NO								
	R	esolution:	Disposition: Q			A: N/C Closed: Date:					
NCR:		V	VORK ORE		(NCR)	)		<b>.</b>	T		
DATE	STEP	Description of NC Section A	Initial	Section B	Sign &		cation on C	Approval Chief Eng	Approval QC Inspector		
		Coolien	Chief Eng	Chief Eng		Date				•	
				-							
	1										

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Work Order ID: 75521	10000100	*7	5521*					4,11-1	
Parent Item: D350-636-013			 350-636	S 012*					
Parent Item Name: Skidtube LH		i.	7.7:307-67.76	)-() (,)			Start Date: Start Qty:	24/10/2011 1.00	Required Date: 07/11/2011 Required Qty: 1.00
D3794-3	Manufactured	No		230	Each	34.0000	1	1	
*D3794-3*							**	B8043	6(X1) 14 11/04/16
			Location	<u>L</u>	oc Qty	Loc Code			
			FP002		34				_
			73423		6				_
			74530		14				-
			74596		14				-
MS21043-6	Purchased	No		230	Each	497.0000		4	1 /
*MS21043-6*							**		nloyly
:			<b>Location</b>	<u>L</u>	oc Qty	Loc Code			
			FG		20				-
			103693		20				-
			ST301		477			- 2 1	-
			112314		267			X 4	-
			117887 118384		10 200				-
MS21083C8	Purchased	No	116364	230	Each	86.0000	1	1	-
*MS21083C8* v		110		230	Buon	00.0000	**	-	12 (XI) He nloy1,
NUT			<b>Location</b>	Lo	oc Qty	Loc Code			
			FP-B	<del></del>	1				
			115884		1				
			ST293		4				
			118077		4				
			ST303		81				
			115884		0				
			118354		6				
			118614		50				
			119309		25				

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W/O:			V	<b>WORK ORDER CHANGI</b>	ES				
DATE	STEP	PRO	CEDURE CI	HANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
									:
	, ·								
Part No		PAR #:	Fault Ca	itegory:	NCR: Yes	No <b>DQ</b>	A:	Date: _	<u></u>
		esolution:		· ·					
NCR:		W	ORK OR	DER NON-CONFORMA	NCE (NC	R)			
DATE	OTED	Description of NC		Corrective Action Section		Verific	ation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date	& Secti		Chief Eng	QC Inspector

Picklist Print October-24-11 1:00:44 PM									Page 10
· Work Order ID: 75521		*7	5521*						
Parent Item: D350-636-013			)350-636-0	<b>ነ</b> 12*					
Parent Item Name: Skidtube LH		•	7. J.	, , , ,			art Date: tart Qty:	24/10/2011 1.00	Required Date: 07/11/2011 Required Qty: 1.00
NAS1149C0832R	Purchased	No		230	Each	345.0000	1	1	
*NAS1149C0832	PR*						**	_Hl	12/04/16
			<b>Location</b>	Loc	Oty	Loc Code			
			FP-B		17			-/1	-
			114915		17			<u> </u>	-
			ST297 114915		328 328				-
NAS1515H3L	Purchased	No		230	Each	103.0000	4	4	-
*NAS1515H3I *							**	111203	60 (xu) Ju (2/04/1/
			<b>Location</b>	Loc	Otv	Loc Code			
			FG		40				-
			102472		40				-
			ST277 113362		63				-
			118686		57 6				-
NAS1611-005	Purchased	No		230	Each	144.0000	8	8	-
*NAS1611-005*							**	11119	438 (x8) He mon/10
			Location	Loc	<u>Oty</u>	Loc Code			
			FP002		144				
			106099		39				
			114220		105				

W/O:			WC	ORK ORDER CHANG	ES			
DATE	STEP	PR	OCEDURE CHA	NGE	Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No		PAR #:	Fault Cator	. Norw	NCD: Voc	No. DOA:	Deter	
T dit 140		solution:						
NCR:				ER NON-CONFORMA				
DATE	STEP	Description of NC		Corrective Action Secti		Verification	Approval	Approval
DAIL	SIEF	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector
٧.								
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-								

October-24-11 1:00:44 PM

'Work Order ID: 75521

Parent Item:

D350-636-013

Parent Item Name: Skidtube LH

\*75521\*

\*D350-636-013\*

Start Date: 24/10/2011

**Required Date:** 07/11/2011

Start Qty: 1.00

Required Oty: 1.00

NAS1611-010

Purchased

Purchased

Manufactured

No

No

No

Each

230

89.0000

Loc Code

17.0000

8 \*\*

\*NAS1611-010\* O-RING

Location			Loc Qty	Loc Code			
FP			65	M12098	6	X (	e
	117460		8			-	
	118077		1				
	118612		56				
FP-A			24				
	110915		14	M120770		<u> </u>	
	119307		10	-			,
		260	Each	65.0000	2	2	V

AN8C21A \*AN8C21A\*

D2741

120094 23

<b>Location</b>	Lo	e Qty
ST343		65
118045		15
118758		50
	260	Each

76984 93 12/04/20

Location Loc Oty Loc Code ST466 17

70667 17

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W/O:			WC	ORK ORDER CHANG	ES			τ.
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
,	,							
						<u></u>		
Part No	•	PAR #:	Fault Cate	gory:	NCR: Yes	No DQA:	Date: _	
		esolution:						
NCR:			WORK ORD	ER NON-CONFORMA	ANCE (NCR	3)		
	T	Description of NC		Corrective Action Section		Verification	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector
								····

• Picklist Print October-24-11 1:00:44 PM										Page 12
Work Order ID: 75521		*75	521*						- 1	
Parent Item: D350-636-013			350-636-0	112*						
Parent Item Name: Skidtube LH		17.	). )()=(). )()=()	11.)			tart Date: 2 Start Qty: 1		Required I Required	Oate: 07/11/2011 Qty: 1.00
D3672-1 *D3672-1* Phenolic Washer	Manufactured	No		260	Each	804.0000	8 <b>**</b>	8 ~	23	
3 Thenone Washer			Location	Le	oc Qty	Loc Code			0	
			FP-A		444					
			52505		0					
			66821		444			66871		
			ST074 72229		360 360					
MS21083C8	Purchased	No	1222)	260	Each	86.0000	2	$\overline{_2}$		
<b>*MS21083C8*</b>	Taronasoa						**	12/04	JB	
			Location	Lo	oc Oty	Loc Code				
			FP-B		1					
			115884		1					
			ST293		4					
			118077		4					
			ST303 115884		81 0					
			118354		6					
			118614		50					
1110110700707			119309		25					
NAS1149D0863J	Purchased	No		260	Each	226.0000	2	2		
<b>*NAS1149D086</b>	3.1*						**		JB	12/04/20
			<u>Location</u>	<u>Lo</u>	c Oty	Loc Code				
			ST298		226					
			118078 119307		126 100			119307		
			117507		100			H 1001		

W/O:	····		W	ORK ORDER CHANG	ES			
DATE	STEP	PRO	OCEDURE CHA	ANGE	Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	,-	PAR #:	Fault Cate	eaory:	NCR: Yes	No DOA:	Date:	
1 471110		esolution:						
NCR:	F-142-P-171.			ER NON-CONFORMA				
		Description of NC	Corrective Action Section		Verification	ation Approval	Approval	
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector
		·						
	ę							

	QTY -041	QTY -042	QTY -043	-044	PART NUMBER	DESCRIPTION
	X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
		х			D2750-042	350 SKIDTUBE ASSEMBLY, RH
			X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			1	X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
	1	1	1	1	D2739	WEB
	8	8	8	8	D2743	SPACER
	1	1	1	1	D2744	CAP
	8	8	8	8	D2745	BUSHING
	1				D2750-1	SKIDTUBE WELDMENT, LH
		1		Ĭ .	D2750-2	SKIDTUBE WELDMENT, RH
			1		D2750-3	SKIDTUBE WELDMENT, LH
				1	D2750-4	SKIDTUBE WELDMENT, RH
	1		1		D3488-041	BLADE FITTING, LH
		1		1	D3488-042	BLADE FITTING, RH
	4	4	4	4	D3490-1	SPACER
	4	4	<u> </u>	<u> </u>	D3490-3	SPACER
	<u> </u>		4	4	D3490-5	SPACER
	8	8	8	8	D3492-041	PLUG ASSEMBLY
	- 8	-8	Ŭ	<del>ٽ</del> ا	D3492-043	PLUG ASSEMBLY
			8	8	D3492-045	PLUG ASSEMBLY
	1	1	1	1	D3535-25	WEARSHOE
	1	1	1	1	D3536-25	GASKET
Æ	3	3	3	3	D3537-1	WEARPAD
Z <u>F</u> Z	8	8	8	- 8	D3631-1	WASHER
Г	1	1	1	1	D3791-1	WEARPLATE
	1	<del>-                                    </del>	1	1	D3793-1	WEARSHOE
1	1	1	1	_ <u>'</u> _	D3793-1	WEARSHOE
A	1	1	1	1	D3793-3 D3794-1	GASKET
	_					
L	_1_	1	1	1	D3794-3	GASKET
Æ	38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
<u> </u>	34	34	34	34	AN3C5A	BOLT
_	4	4	4	4	AN3C6A	BOLT
	4	4	4	4	AN6C44A	BOLT
	1	1	1	1	AN8C35A	BOLT
^ .	38	38	38	38	AN960C10L	WASHER
<u>/F\</u>	1	1	1	1	AN960C816L	WASHER
_	4	4	4		MS21043-6	NUT
	1	1	1		MS21083C8	NUT
	4	4	4		NAS1515H3L	WASHER

**GENERAL NOTES:** 

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MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).

FINISH:

ACID ETCH, ALONDE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.

POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3

BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).

TOLERANCES: PER DART QSI 018 UNILESS OTHERWISE NOTED

UNITS: INCHES UNILESS OTHERWISE NOTED

BREAK SHARP EDGES: N/A

IDENTIFICATION: N/A

WEIGHT: D2750-0041002-0443-044 = 26 5 LBS

IDENTIFICATION: NIA
WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
WEID PER DART QSI 004
INSTALL AL.S4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES (Ø 0.297) FOR WEARSHOE INSERTS
FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
MINIMUM YIELD TENSILE STRENGTH = 35 KSI
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS.
COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF
POWDER COATING WITH MEK DEGREASER.
SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

SHOTOGRAPY Rining ENCTAINED BOLLY UNCONTRUCTOR SUBJECT TO AND HOLD AND WITHURD NEED, NO ASSAL M.C.J

2

11/10/24



F	QTY (3) D3791- D3794- ADD D3 WEARS (8 PL), 1 D3488- ADD NO	3791-1 (ZN C8- SHOE HOLES 1	C DTY (5) (ZN C8-1); S D3535-137-35 (ZN C8-1); S D3536-137-35 (ZN B8-1); I); INDER FWD/AFT SADDLE REMOVED ARDWARE OTY UPDATED (ZN B8-1); WARE UPDATED (ZN C1-8, 9, 10, 11); I (ZN A6-1);	PН	08.07.16
E	ADD RL	IBBER GASKE	SS STEEL WEARPLATES; TS; CHANGE INSERTS; ADD D3631-1; S1515H3L; REMOVE QTY (10) E D2741, QTY (2) AN960C816; 21083C8	CB	07.05.17
D	ADD HO	LES AND SHA	PH	06.01.05	
С	ADD D2	750-3/D2750-4	INCORPORATE D2738 AND D2740	CP	98.11.18
В	CHANG	E MS24694-S2	93 TO AN8-16A	CP	98.09.01
Α	NEW IS	SUE		DS	98.04.16
REV.			DESCRIPTION	BY	DATE
DESIGN	1	P\$	DART AEROSPACE	USA	INC.
DRAW	7	RH	PORT HADLOCK		
CHECK	ED	1 1	DRAWING NO.		REV. F
MFG. A	PPR.	ALC:	D2750	S	SHEET 1 OF 11
APPRO					SCALE
DE APF	R.	1	MBLY	NTS	

5

DATE

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08.07.16

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USED FOR ANY PAYROSS OF COMPON COMMONDICATED TO ANY OTHER PERSON WITHOUT

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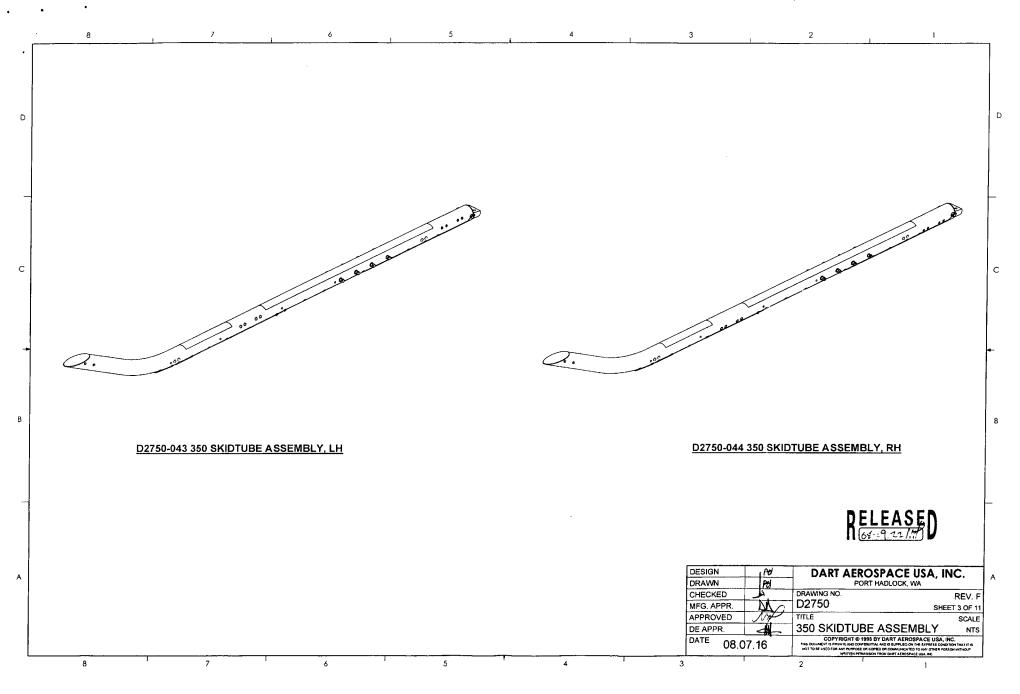
W/O:			WO	RK ORDER CHANG	SES				
DATE	STEP	PR	OCEDURE CHAN	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	):	PAR #:	Fault Categ	ory:	NCR: Yes	No DQA	•	Date: _	·
	Re	esolution:	Disposition	:	_ QA: N/C C	losed:		Date: _	<del></del>
NCR:			WORK ORDE	R NON-CONFORM	ANCE (NC	R)			
DATE	STEP	Description of NC Section A	Initial	Corrective Action Section Description	escription Sign		ation n C	Approval Chief Eng	Approval QC Inspector
		Section A	Chief Eng	Chief Eng	Date	Const		07.107 E11g	QO MOPOSION

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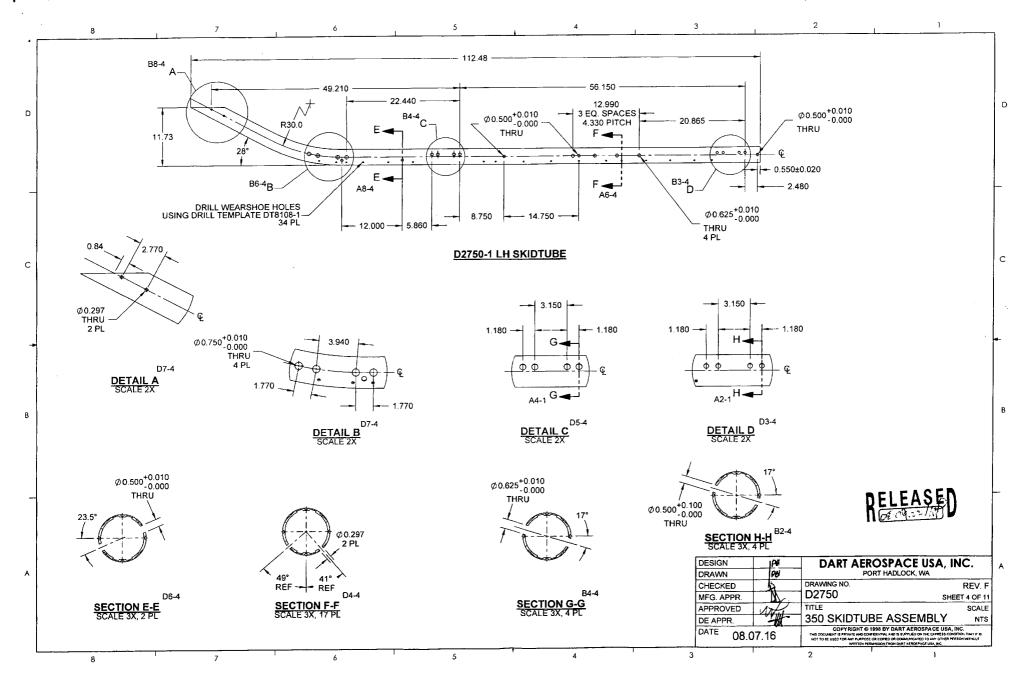
D2750-041 350 SKIDTUBE ASSEMBLY, LH D2750-042 350 SKIDTUBE ASSEMBLY, RH DART AEROSPACE USA, INC.
PORT HADLOCK, WA DESIGN DRAWN DRAWING NO. CHECKED REV. F D2750 MFG. APPR. SHEET 2 OF 11 TITLE APPROVED SCALE 350 SKIDTUBE ASSEMBLY

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THE OCUMENT A PRIMATE AND COPTION AND AND AND THE STRINGS CONDING HAS IT IN DE APPR. NTS DATE 08.07.16

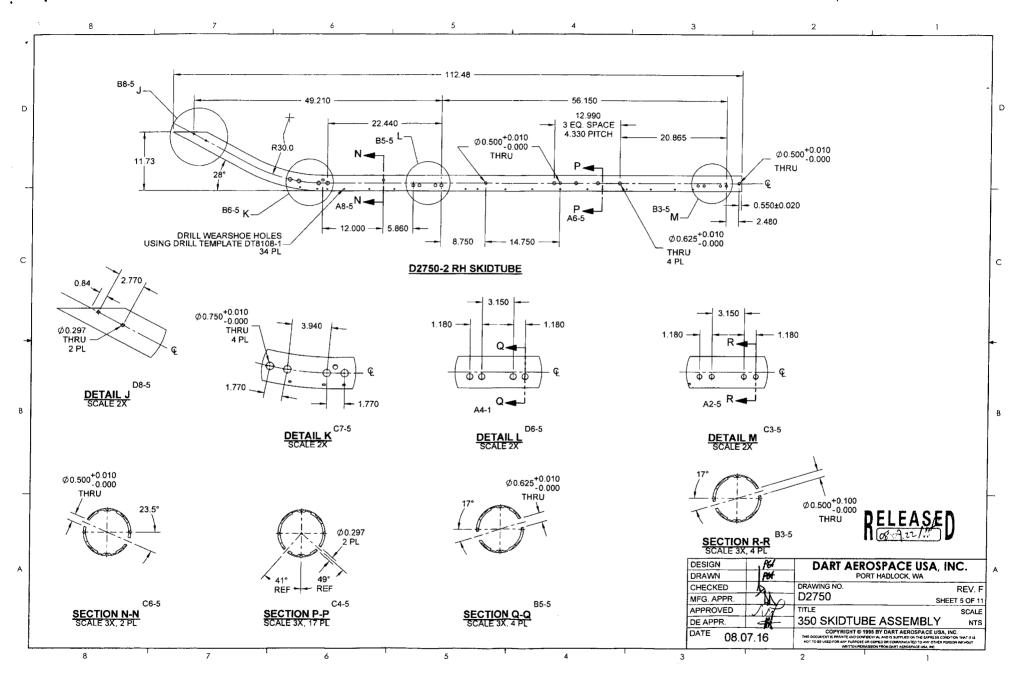
W/O:			WC	RK ORDER CHANG	GES			
DATE	STEP	PR	OCEDURE CHAI	NGE	Ву	Date Qt	Y Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No: PAR #: _								
	Resolution: Disposition: WORK ORDER NON-CON						Date: _	
NCR:					•	)		
DATE	STEP	Description of NC	cription of NC Section A  Corrective Action Initial Action Desc		tion B Sign &	Verificatio		Approval
		Section A	Chief Eng	Chief Eng	Date	Section C	Chief Eng	QC Inspector
	P							



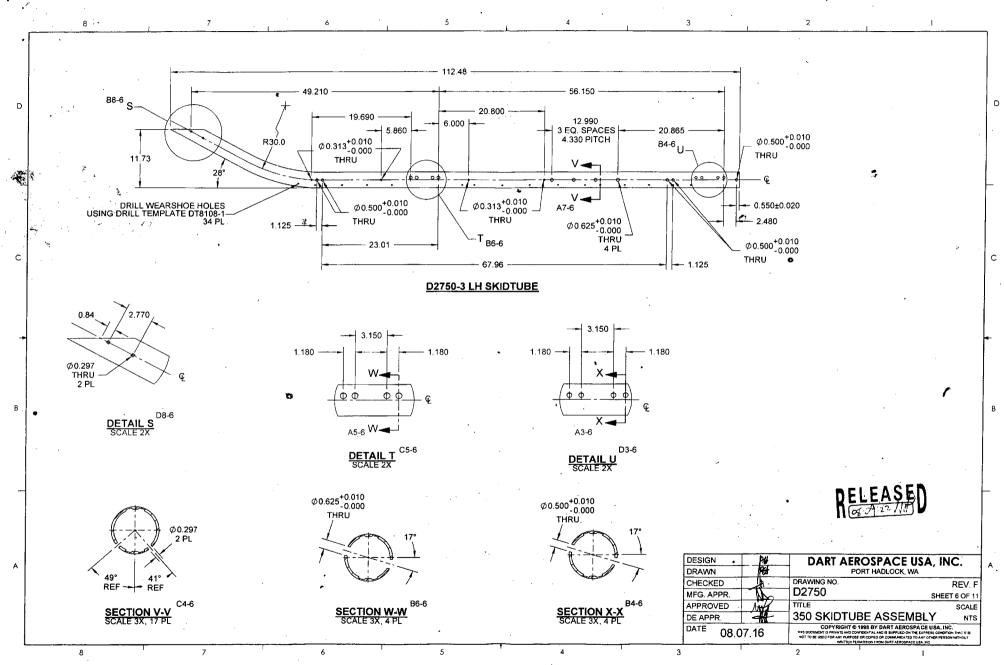
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DATE	STEP	PR	OCEDURE CHA	NGE	Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
Part No: PAR #:					DQA: Date:				
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DATE	STEP	Description of NC	escription of NC Corrective Action			Verification	Approval	Approval	
DAIL	JILI	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector	



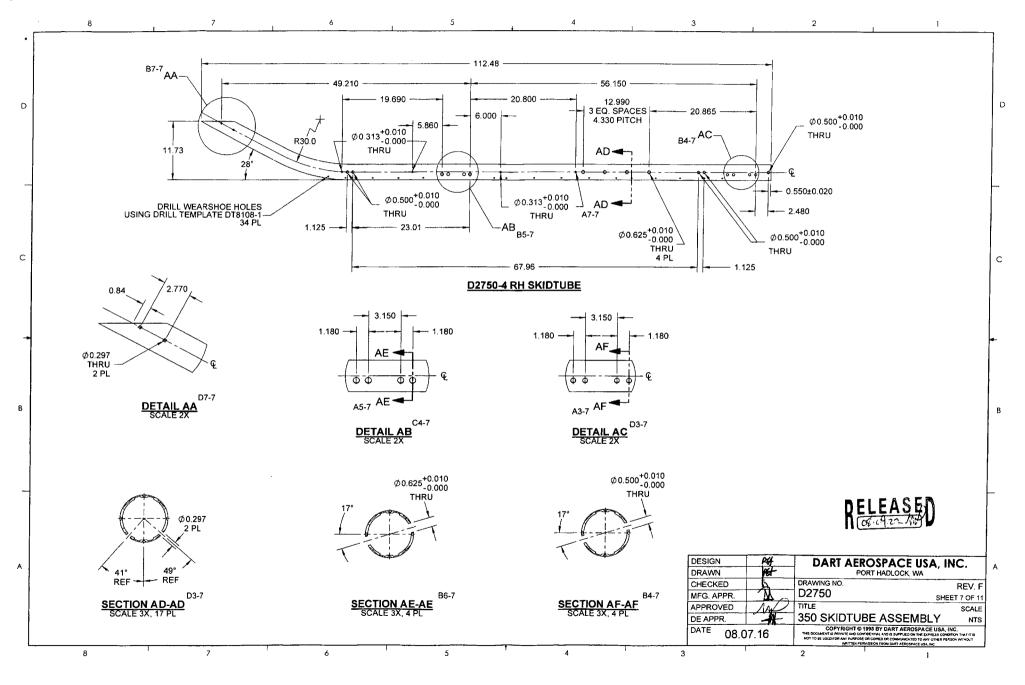
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	R	esolution:					Date: _	
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		Description of NC	Corrective Action Section B			Verification	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector
				•				
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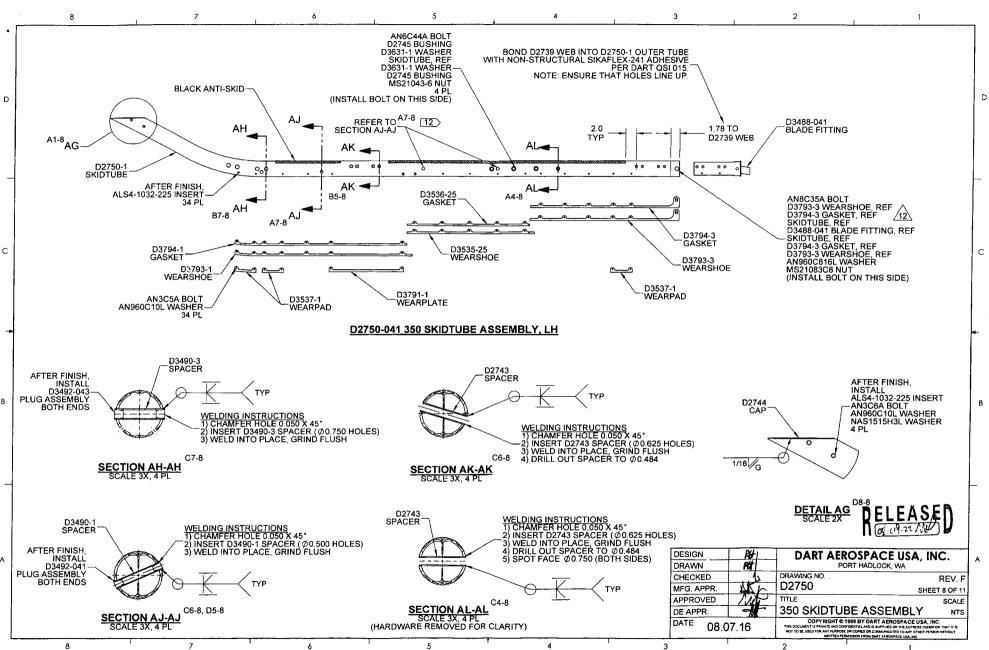
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DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Section Description Chief Eng	tion B Sign & Date		Approval Chief Eng	Approval QC Inspector
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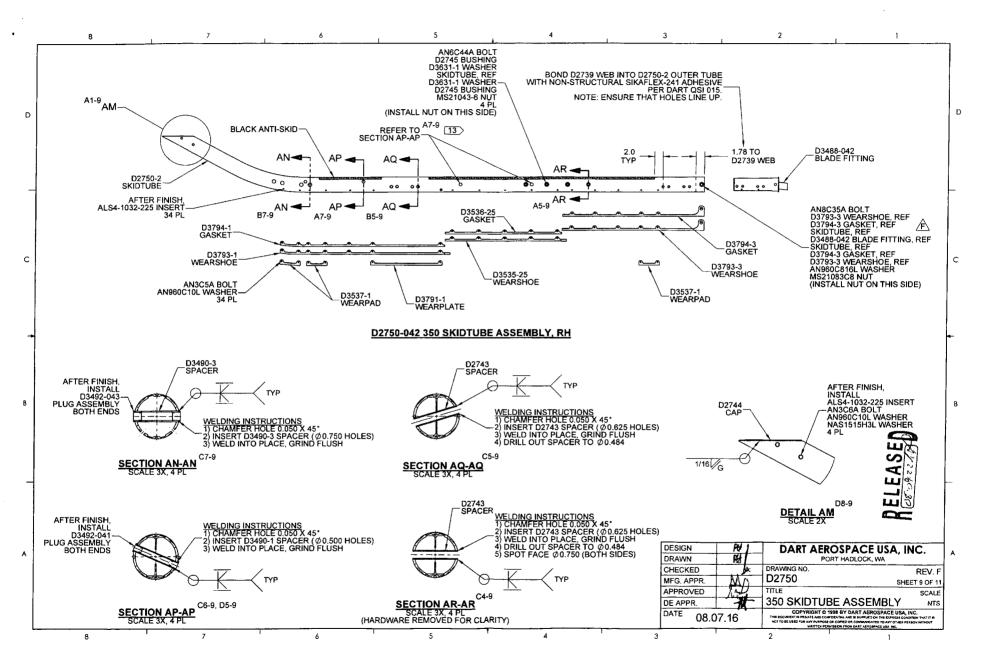
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		Description of NC		Corrective Action Section I			ication	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date		tion C	Chief Eng	QC Inspector
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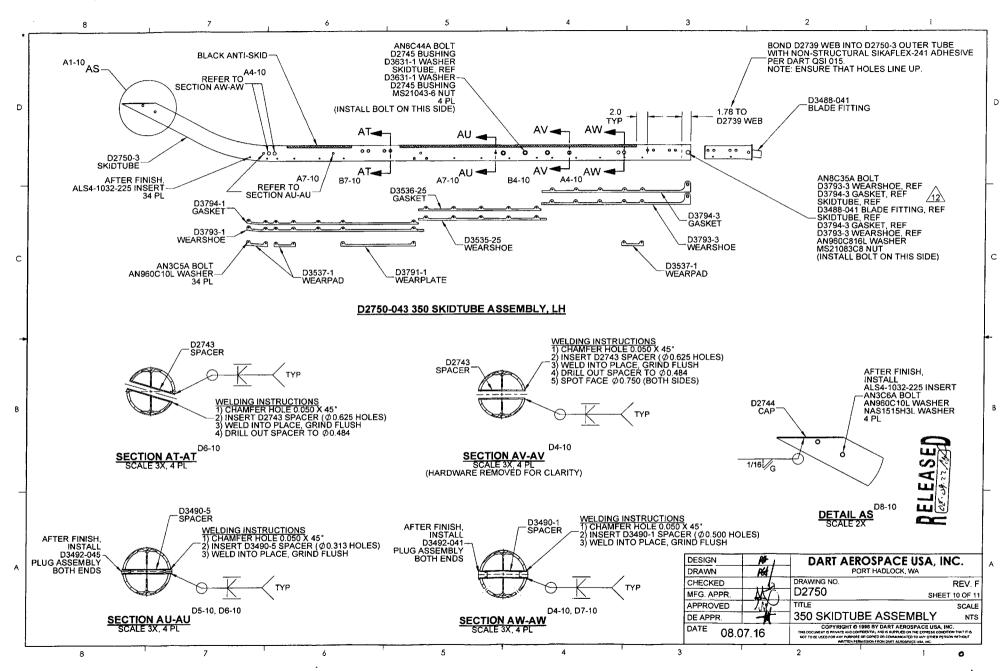
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Part No	):	PAR #:	Fault Categ	jory:	NC	R: Yes	No <b>DQ</b>	A:	Date:	
	R	esolution:							Date: _ 	
NCR:			WORK ORDE	R NON-CONFO	RMANCE	E (NC	R)			
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Action Descrip	Section B	Sign Date	& Sect	cation ion C	Approval Chief Eng	Approval QC Inspector
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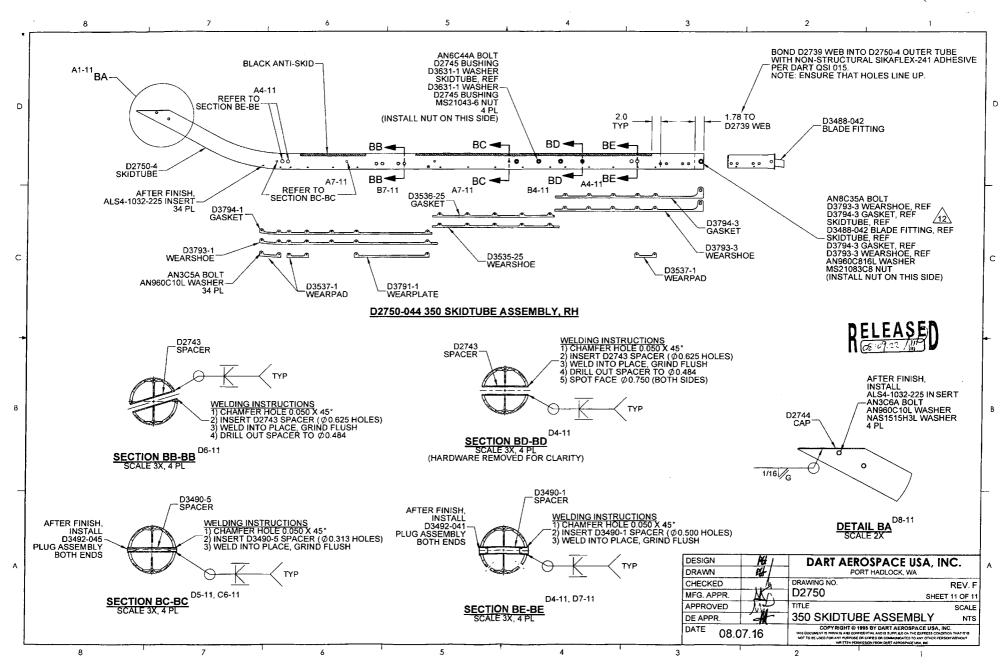
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W/O:			WO	RK ORDER CHANGES	<b>3</b>		,		, <u>, , , , , , , , , , , , , , , , , , </u>
DATE	STEP	PRO	OCEDURE CHAN	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
D 4 N		PAR #:	Fault Cateo	IOTV:	NCR: Yes	No <b>DQ</b>	A:	Date:	
Part No	): R	esolution:	Pault Categ	l:	QA: N/C Clo	osed:		Date: _	
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DATE	STEP	Description of NC Section A	tion of NC Initial Action D Chief Eng Chief		Sign & Date	Verific Secti	cation ion C	Approval Chief Eng	Approval QC Inspector
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W/O:	. <b></b>		WΩ	RK ORDER CHANG	ES			•	٠.,
DATE	STEP	PR	OCEDURE CHAN		Ву	Da	ite Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
						-		Prod Mgr	
Part No	Part No: PAR #: _		Fault Categ	ory:	_ NCR: Ye	es No	DQA:	Date: _	
	R	tesolution:	Disposition	:	_ QA: N/C	Close	d:	Date: _	
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		Description of NC			tion B		Verification	Approval	Approval
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng		n & ate	Section C	Chief Eng	QC Inspector
	-								



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	Resc	olution:	Disposition	1:	QA: N	NC CI	osed:		Date: _	
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DATE	STEP	Description of NC	Corrective Action		tion B	Sign &		cation	Approval	Approval
UATE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng		Date	Sec	tion C	Chief Eng	QC Inspector



W/O:		WORK ORDER CHANGES							•	
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	୍ଲ ଅନ	esolution:	tion: QA: N/C Closed:					Date:		
NCR:	- 4	V	VORK ORE	DER NON-CONFORMA	NCE	(NCR	)			T
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Section  Action Description  Chief Eng	on B	Sign & Date	Verific Section		Approval Chief Eng	Approval QC Inspector
		Pro-	Criter Eng	Ond Eng						
	**								<b>15</b>	
			Mar.							
·	=									

NO. <u>289</u>

# AWS D17.1.2001 QUALIFICATION TEST RECORD

D	Landou Fliatt	
Name:	Ling Fillow	
Job number:_	01900	
Part number:	1350-636-016	
Description:	Shidtelse	
Welding Proce	ess: Tig[/ Mig[]	•
Base materiel:		
Current: AC	[/] DC[ ]	

## TEST REQUIREMENTS AND RESULTS

Visual: Penetration:	pass[] fail[] pass[] fail[]
UNACCEPTABLE	. ·
Cracks: Undercut: Pin holes: Overlap (cold lap) Porosity (surface): Coloration:	pass[ fail[ ]
Qualifier found funch Welder Borela Ellers	Date of Test Coupon 12.04.17  Date of Test Coupon 12.04.17
	ANTO D17.1.2001 to a